

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007192**Date Inspected:** 29-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG Components				

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Trial Assembly Area

This QA Inspector, George Goulet, randomly observed the following in the trial assembly area:

No ZPMC workers were performing bolting work. ASTM A325 bolt sets had been installed in many connections between panel point 24 and panel point 28, but many were missing and the condition was undetermined. Also, many bolts installed were less than flush with the outer face of the nuts. Many of the connections near the end plates at the deck plates and side plates exhibited gaps between faying surfaces from less than 1 mm to more than 3 mm and some had metal shavings between the faying surfaces.

The following connections were the only connections observed to have turn-of-nut markings: PP24, lower chevron, south side; PP25, lower chevron, south side; PP26, lower chevron, south side; PP27, lower chevron, south side; PP28, lower chevron, south side. Many of the bolts were unmarked or poorly marked and some appeared to have been rotated less than 180° from the original snug tight position.

This QA Inspector, George Goulet, reviewed the Caltrans-approved SFOBB Project HS Bolt Installation and Inspection Plan, Addendum to the Quality Acceptance Procedure (Bolting), and the RCSC Specification for Structural Joints Using ASTM A325 or A390 Bolts.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George
----------------------	---------------

Quality Assurance Inspector

Reviewed By:	Carreon,Albert
---------------------	----------------

QA Reviewer
